

Work Order ID 72658

Thursday, August 04, 2011 8:14:16 AM

Page 1

Item ID: DSK079

Accept

Revision ID:

Item Name: D2894-1 TURNING DETAIL

Start Date: 8/4/2011 Start Qty: 6.00

Required Date: 8/5/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSK079

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA253

11-8-15

6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-8-15

6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11-8-11

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72658

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Page 2

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QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: CNC

52 11/8/16

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/8/18

MR

11-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 04, 2011 8:14:23 AM

Page 1

Work Order ID: 72658

Parent Item: DSK079

Parent Item Name: D2894-1 TURNING DETAIL

Start Date: 8/4/2011

Required Date: 8/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-009		Manufactured	No				Each	10.0000		6			
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27 11-8-15

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

10

41968

10

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72651
Description: Turning Detail for D2894-1		Part Number:	DSK079
Inspection Dwg: DSK079		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.778	2.783		2.783	2.783	2.783	2.783	2.783
B	3.990	4.010		3.997	4.002	4.000	3.997	3.997
C	3.088	3.108		3.100	3.100	3.100	3.100	3.100
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.968	2.988		2.980	2.980	2.980	2.980	2.980
G	1.410	1.430		1.420	1.420	1.420	1.420	1.420
H	1.150	1.160		1.157	1.157	1.157	1.157	1.157
I	5.240	5.260		5.250	5.250	5.250	5.250	5.250
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.090	0.110		.100	.100	.100	.100	.100

Measured by: <i>De</i>	Date: 11.8.15
Audited by: <i>SA</i>	Date: 11/8/16
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>SA</i>

W/O:		WORK ORDER CHANGES					
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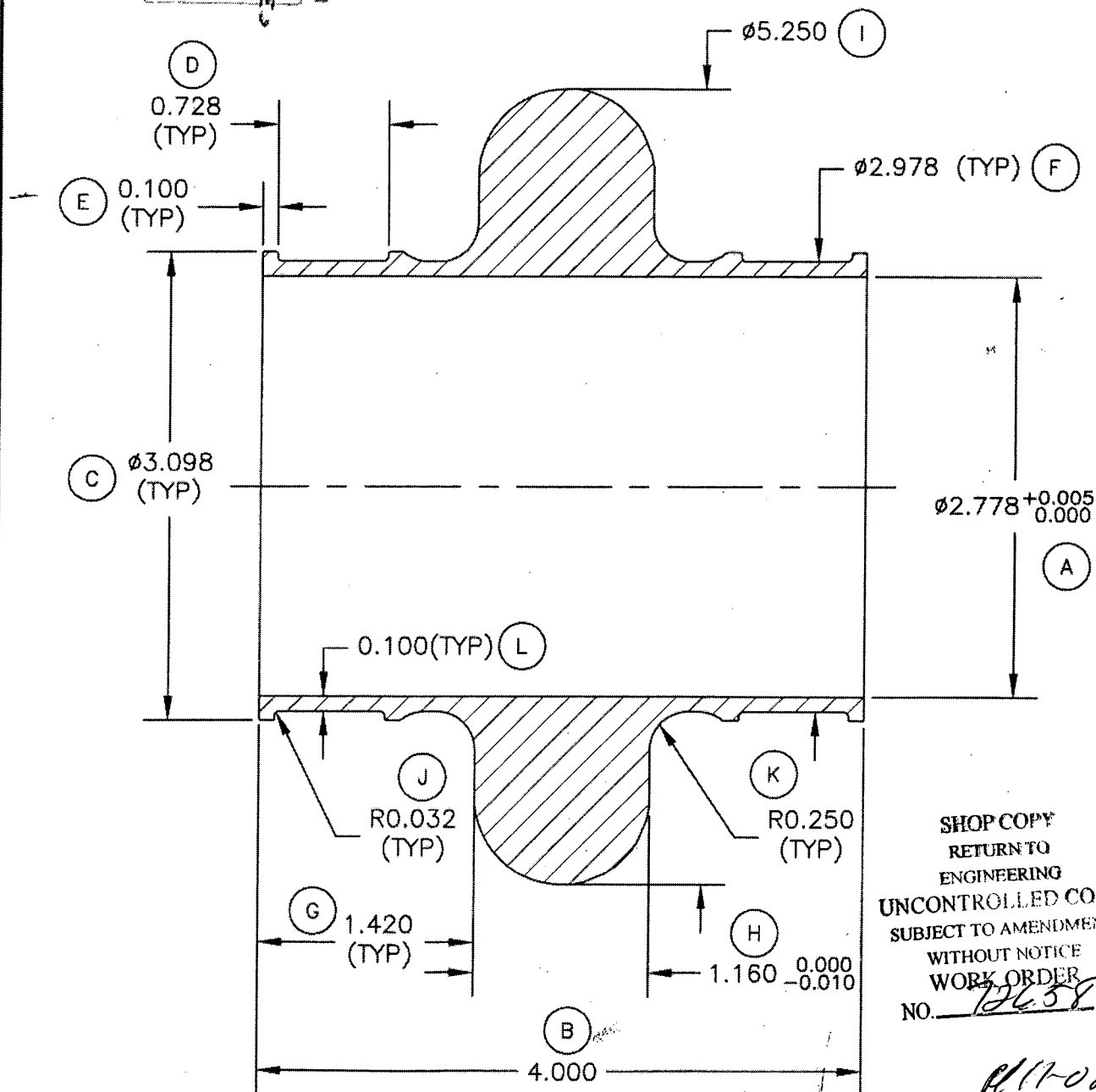
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NOTE: Date & initial all entries



DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. DSK 079	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2894-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *12658*

R11-08-4

D2894-1 TURNING DETAIL

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